

Work Order ID . 76816

76816

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Monday, November 21, 2011 1:17:35 PM

Item ID: D2620 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube, 206 Skidtube
Start Date: 11/21/2011 Start Qty: ~~10.00~~ **5** ~~*10*~~ Cust Item ID:
Required Date: 12/14/2011 Req'd Qty: ~~10.00~~ **5** ~~*10*~~ Customer:
Reference:

Approvals: Process Plan: M.L.S Date: 11/11/12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2620 | Rev B | | | | | | | | |

100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
206.A and Folio Ft0082- Cut Fwd end of tube as per Dwg D2620

MO
JW

11-12-13

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

0.00

DP

11-12-13

120

Identify as per dwg & Stock Location: LG

0.00

120

Packaging

Packaging

Memo

0.00

MO

11-12-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 76816***76816***

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Monday, November 21, 2011 1:17:35 PM

Item ID: D2620

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube, 206 Skidtube

Start Date: 11/21/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/14/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

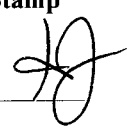
130

QC

Memo

0.00

Quality Control

11/12/14 MF
11-12-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 1:17:39 PM

Page 1

Work Order ID: 76816

76816

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 11/21/2011

Required Date: 12/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-1-120 | | Manufactured | No | | | | Each | 58.0000 | | 10 | | | |
| *D2600-1-120* | | | | | | | | | ** | | | | |
| Extrusion Round 3" 206 | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

LG

58

73804

58

5 mo 11-12-13

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

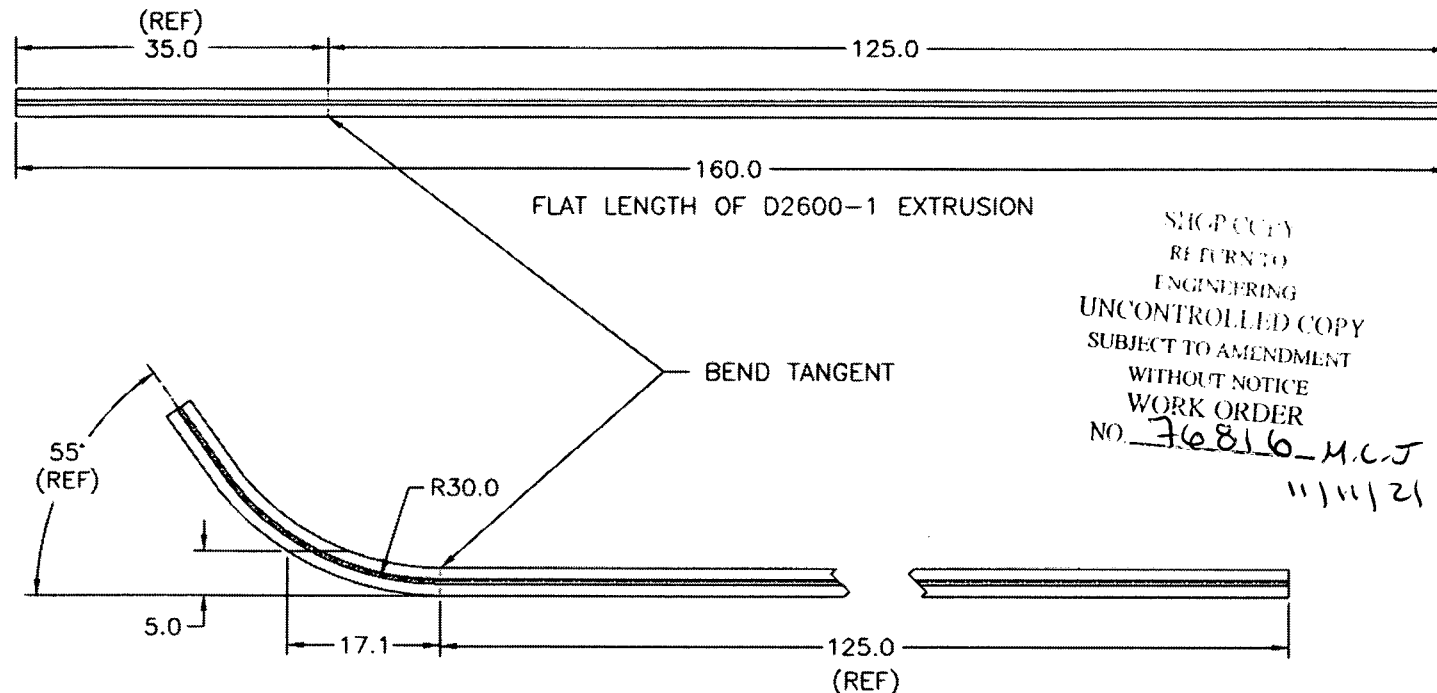
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



SHOCCY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76816-M.C.J
11/11/21

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES



| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|----------|------------------------------|------------------------------------|
| CHECKED | APPROVED | FARCHILD INTERNATIONAL AIRPORT, WA |
| DATE | TITLE | REV. B |
| 99.09.10 | 206 SKIDTUBE BENDING CONTROL | SHEET 1 OF 1 |
| A | 97.11.07 | SCALE |
| B | 97.09.10 | 1:20 |
| | UPDATE FOR IN-HOUSE BENDING | |

RELEASED
99 09.15 DS

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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